

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010733**Date Inspected:** 16-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG / Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

5CE

SMAW tack welding on weld joints 011, 012, 013, 014 and 015 located at SEG026C on LD2H bike path side of segment between panel point 35&36. Welder is identified as Mr. Feng Huajun (066258). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U2-F, WPS-B-T-2233-B-U2-F and ZPMC RFI 001938R01.

6BW+6AW

FCAW welding on weld joints 21, 23, 25, 27, 29 and 31 located at BP140-001.

Welder is identified as Mr. Li Shoufu (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

FCAW welding on weld joints 21, 23, 25, 27, 29 and 31 located at BP032-001.

Welder is identified as Mr. Li Shoufu (067942). ZPMC QC is identified as Li Yang. The welding variables

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recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

6AW

SMAW welding on weld joints 025, 027 and 029 located at SP202-005 on panel point 39 cross beam side of segment. Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

SMAW welding on weld joints 025, 027 and 029 located at SP205-005 on panel point 40 cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

SMAW welding on weld joints 025, 027 and 029 located at SP201-005 on panel point 40 cross beam side of segment. Welder is identified as Mr. Feng Changdou (066261). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

5BW+5CW

SMAW repair welding on weld joint 007 located at OBW5G on counter weight side of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

6BW

FCAW welding on weld joint 006 located at SEG029C on bike path side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performed and accepted MT on various locations in the trial assembly yard.

5AW+5BW

1. Weld splice OBW5-003 (internal) located on deck plate.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
